

Work Order ID 92103-2

Tuesday, October 23, 2012 4:08:32 PM

Page 1

Split -1

\*92103\*

Item ID: PB67-43001-59

Revision ID:

Item Name: PB67-43001-59

Start Date: 10/23/2012 Start Qty: 4.00

Required Date: 11/2/2012 Req'd Qty: 4.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

\*4\*  
\*4\*

Approvals: Process Plan: ML5

Date: 12-10-25 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-59	Rev C								

100

\*100\*

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to

4

φ

12

12.11.22

110

\*110\*

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

④ 12-11-22





# Work Order ID 92103

Tuesday, October 23, 2012 4:08:32 PM

\*92103\*

Page 2

Item ID: PB67-43001-59

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: PB67-43001-59

Start Date: 10/23/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality-Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

Hand Finish

Memo

0.00

Hand Finishing

140

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

\*140\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

MI 8144

3:40  
320°F  
4:10

4 26 12-11-22

4X ✓ 12/11/22





# Work Order ID 92103

Tuesday, October 23, 2012 4:08:32 PM

\*92103\*

Page 3

Item ID: PB67-43001-59

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: PB67-43001-59

Start Date: 10/23/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

150

QC3- Inspect Part Finish

0.00

\*150\*

QC

Memo

0.00

Quality Control

4 0 12-11-23



160

Small Fab

0.00

\*160\*

Small Fab

Memo

0.00

1- take -267 and transfer drill holes in -113 as per dwg PB67-430012- deburr  
and rivet -267 to -113 as per dwg3- assemble rest of parts as per dwg PB67-  
43001

2

0

12-12-12

170

QC5- Inspect part completeness to step on W/O

0.00

\*170\*

QC

Memo

0.00

Quality Control

Pl 12-12-12

2x





# Work Order ID 92103

Tuesday, October 23, 2012 4:08:32 PM

**\*92103\***

Page 4

Item ID: PB67-43001-59

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: PB67-43001-59

Start Date: 10/23/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run

Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/

Work Center ID

Operation

Description

Set Up/

Run Hours

Tool ID

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

180

Identify as per dwg & Stock Location: *111A*

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

*2*

*φ*

*12.12.12*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/12/13 φ*

*pl 12-12-12*





# Picklist Print

Tuesday, October 23, 2012 4:08:31 PM

Page 1

Work Order ID: 92103

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-18 new issue DD verified by:cc  
IPP Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified by: eC IPP RevC  
10.09.29 per revC dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-121 Square Sleeve		Manufactured	No			160	Each	2.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST445		2							
				43329		2							
PB67-43001-267 PB67-43001-267		Manufactured	No			160	Each	6.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST439		6							
				44976		6							
30345T21 LANYARD		Purchased	No			160	Each	31.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		31							
				17828		31							
BSP43 RIVET		Purchased	No			160	Each	39.0000	4	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		39							
				110704		36							
				111127		3							

B90898 → (2) Ae 12/11/26

(2) Ae 12/11/26

(4) Ae 12/11/26

(8) m123482 → (6) Ae 12/11/26

(10)



# Picklist Print

Tuesday, October 23, 2012 4:08:31 PM

Page 2

Work Order ID: 92103

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

MS17984-C413

PIN, QUICK RELEASE

Purchased

No

160

Each

27.0000

2

8

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

12-12-12

## Location

## Loc Qty

## Loc Code

ST315

3

114340

1

118612

2

ST331

24

122800

14

123346

10

MS21042L3

Nut

Purchased

No

160

Each

3,172.0000

2

8

12/11/26

## Location

## Loc Qty

## Loc Code

316

627

122452

627

ST300

338

117885

32

119017

168

119075

138

ST314

1781

123265

1781

ST317

426

122141

426

MS27039-1-22

SCREW

Purchased

No

160

Each

288.0000

2

8

12/11/26

## Location

## Loc Qty

## Loc Code

ST291

134

112940

100

18057

34

ST292

154

112940

100

18057

54

Tuesday, October 23, 2012 4:08:31 PM

Shop Packet Print

Page 2





# Picklist Print

Tuesday, October 23, 2012 4:08:31 PM

Page 3

Work Order ID: 92103

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Washer

Purchased No 160 Each 4,436.0000 4 16

*At 12/11/26*

## Location

## Loc Qty

## Loc Code

ST294

4436

122973

4436

*(16)*

NAS1149DN416J

Washer

Purchased No 160 Each 236.0000 4 16

*At 12/11/26*

## Location

## Loc Qty

## Loc Code

ST297

236

114597

43

122151

192

13910

1

*(16)*

PB67-43001-105

Plug

Manufactured No 100 Each 5.0000 1 4

*12.11.21*

## Location

## Loc Qty

## Loc Code

WA

5

85213

5

*4*

PB67-43001-113

Square Tube

Manufactured No 100 Each 0.0000 1 4

*12.11.21*

PB67-43001-117

Tube End Plate

Manufactured No 100 Each 0.0000 1 4

*12.12.12*

## Location

## Loc Qty

## Loc Code

ST445

6

24807

6

*24*

PB67-43001-117

Hook Plate

Manufactured No 100 Each 5.0000 1 4

*12.12.12*

## Location

## Loc Qty

## Loc Code

ST

5

85214

5

*4*

PB67-43001-119

End Cap Clevis

Manufactured No 100 Each 0.0000 1 4

*12.12.12*

*B 90897*

Tuesday, October 23, 2012 4:08:32 PM

Shop Packet Print

Page 3





# Picklist Print

Tuesday, October 23, 2012 4:08:32 PM

Page 4

Work Order ID: 92103

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

PB67-43001-271

Doubler

Manufactured No

100

Each

11.0000

1

4

12.11.22

Location

Loc Qty

Loc Code

ST438

11

44975

11

4

PB67-43001-275

Doubler

Manufactured No

160

Each

4.0000

1

4

12.11.22

Location

Loc Qty

Loc Code

ST

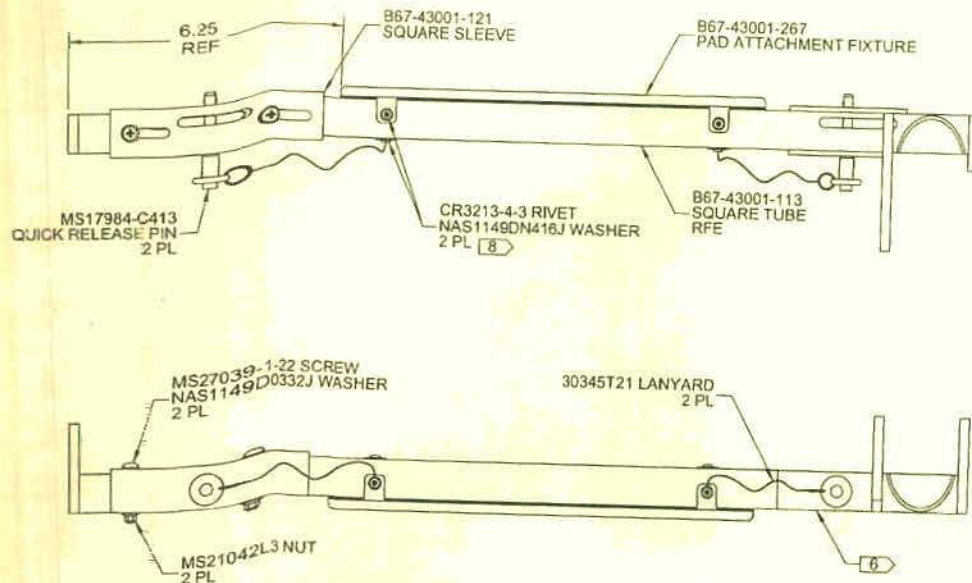
4

85645

4

4



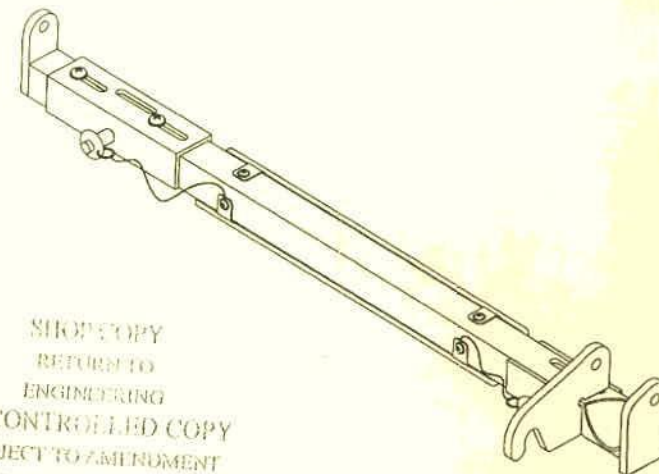


**B67-43001-59 ADJUSTABLE ATTACHMENT ARM**

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-59" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs
- 8) FOLD -267 TABS OVER AND TRANSFER DRILL Ø0.130 FROM -267 TO -113 PRIOR TO INSTALL CR3213-4-3 RIVETS.

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
3	1	B67-43001-121	SQUARE SLEEVE
4	1	B67-43001-267	PAD ATTACHMENT FIXTURE
6	2	30345T21	LANYARD
7	4	CR3213-4-3	RIVET (OR BSP43-4-3)
8	2	MS17984-C413	QUICK RELEASE PIN
9	2	MS21042L3	NUT
10	2	MS27039-1-22	SCREW
11	4	NAS1149D0332J	WASHER
12	4	NAS1149DN416J	WASHER



SHOPE COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

92103 HLT  
12-10-25

RELEASED  
2010-09-15

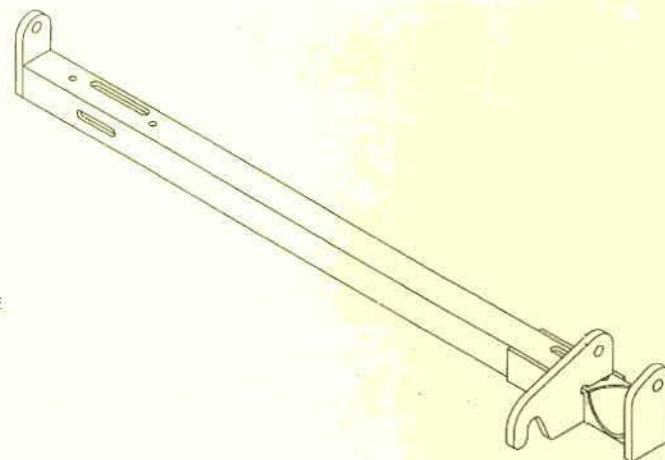
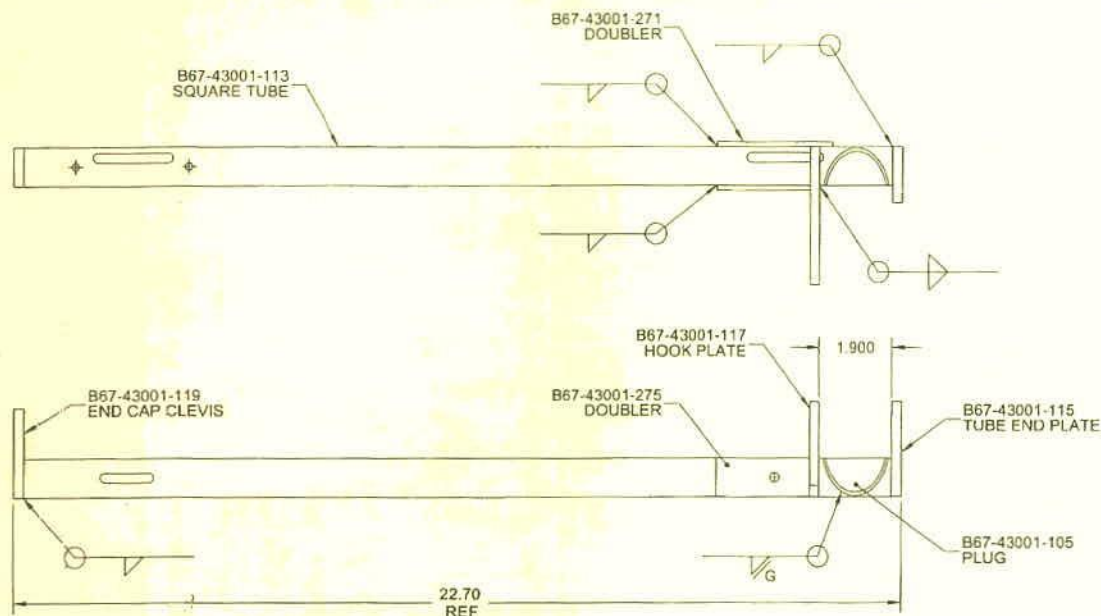
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 14 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR009-011.		MB	09/06.15
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	4JS	DRAWING NO. <b>B67-43001-59</b>		REV. C
MFG. APPR.		TITLE		SHEET 1 OF 2
APPROVED	M/D	ADJUSTABLE ATTACHMENT ARM		SCALE
DE APPR.	N/A	DATE		NTS
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1871  
1872  
1873

92103

ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59W	ADJUSTABLE ATTACHMENT ARM WELDMENT
3	1	B67-43001-105	PLUG
4	1	B67-43001-113	SQUARE TUBE
5	1	B67-43001-115	TUBE END PLATE
6	1	B67-43001-117	HOOK PLATE
7	1	B67-43001-119	END CAP CLEVIS
8	1	B67-43001-271	DOUBLER
9	1	B67-43001-275	DOUBLER



**B67-43001-59W ADJUSTABLE ATTACHMENT ARM  
(WELDING DETAIL)**

**RELEASED**  
R 2010-09-16  
AM

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.28 lbs
- 8) WELDING: PER QSI 004
- 9) MASK ALL HOLES AND OPENINGS PRIOR TO POWDER COAT

DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. C
CHECKED	AS	<b>B67-43001-59</b>	SHEET 2 OF 2
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AM	<b>ADJUSTABLE ATTACHMENT ARM</b>	NTS
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DATE	09.06.15		

